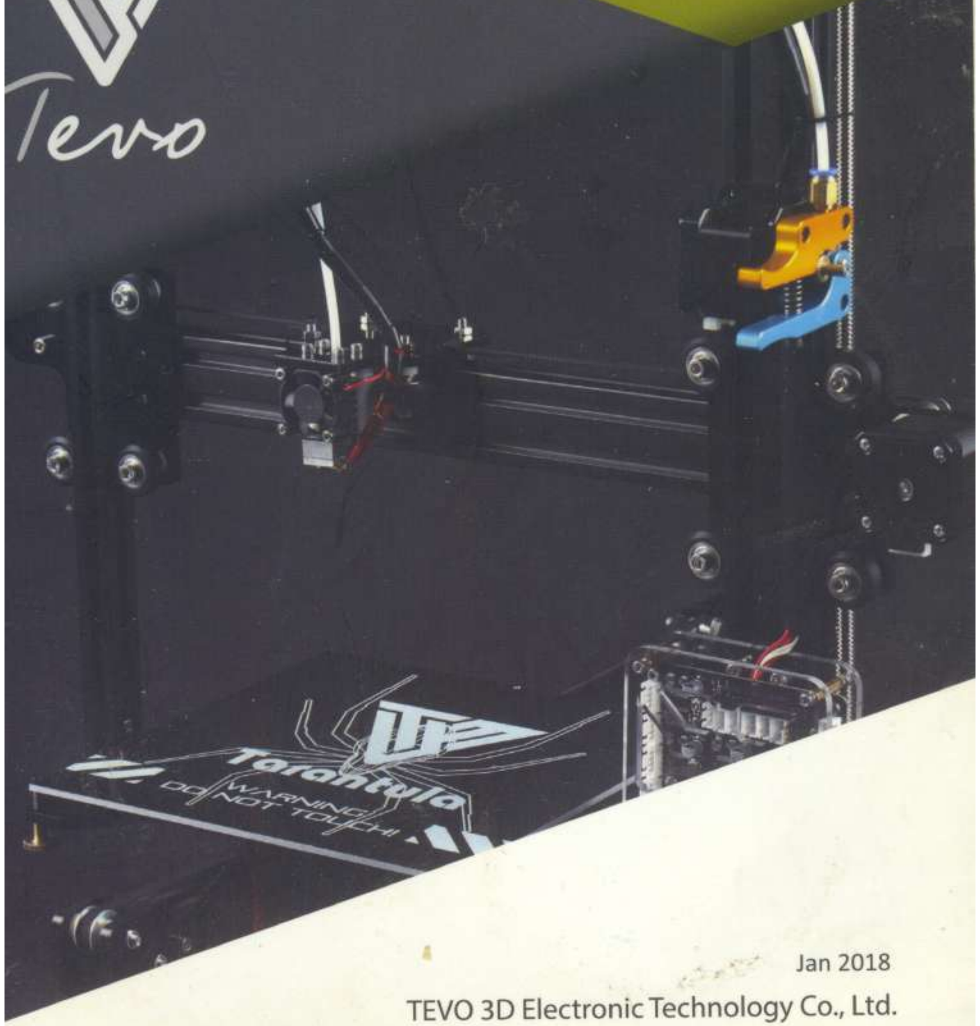
TEVO TARANTULA
ASSEMBLY MANUAL



Jan 2018

TEVO 3D Electronic Technology Co., Ltd.

READ ME FIRST

READ THIS MANUAL COMPLETELY BEFORE ASSEMBLING AND POWERING UP YOUR PRINTER!

Hazards and Warnings

The TEVO Tarantula 3D printer has motorized and heated parts. When the printer is in operation always be aware of possible hazards.

Electric Shock Hazard

Never open the electronics bay of the printer while the printer is powered on. Before removing the access door, always power down the printer and unplug the AC line cord.

Burn Hazard

Never touch the extruder nozzle, heater block, or the heated bed without first turnnig off the hotend (or heated bed) and allowing it to completely cool down. The hotend (or heated bed) can take up to twenty minutes to completely cool down. Also, never touch recently extruded filaments. The filament can stick to your skin and causes burn.

Fire Hazard

Never place flammable materials or liquids on or near the printer when powered on or in operation. Liquid acetone and vapours are extremely flammable.

Pinch Hazard

When the printer is in operation, be careful never to put your fingers in the moving parts, including the belts, pulleys, gears, wheels or leadscrews.

Static Charge

Make sure to ground yourself before touching the printer, especially the electronics Electrostatic charges can damage electronic components. To ground yourself, touch a grounded source.

Age Warning

For user under the ages of 18, adult supervision is recommended. Beware of choking hazards around children.

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Letter from TEVO

Dear Customer,

Thank you for purchasing the TEVO Tarantula 3D printer.

This guide will step you through the assembly and the first run of the printer. If you have any problems during assembly, please go to our Facebook group:
https://www.facebook.com/groups/TEVO.3dprinter.owners/

If you cannot resolve your problem there, do not hesitate to contact us through
http://support.tevoprinter.com/

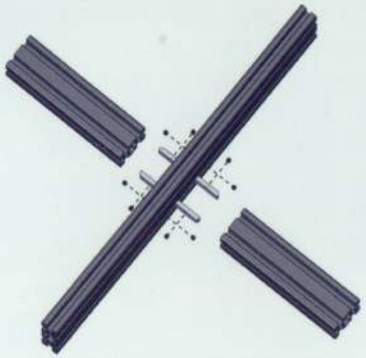
This manual begins by showing all needed parts for the frame assembly. Please check if those parts are all in your package and check if all rods are straight. You can do this by placing them on a flat table and see if they roll. While checking the parts please do not mix the parts of the Bags A-1 to A-8. Keep them separated to prevent using the wrong parts during assembly.

After checking the parts, complete each steps using the parts listed only.

Please make sure that the frame is completely square and tight in every angle by using a gemmetrical triangle or any other more sophisticated square tools (not supplied with the printer kit.)

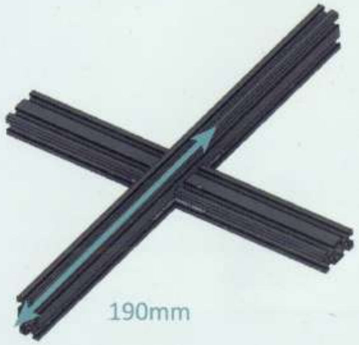
Regards,
TEVO Team

The Chassis Rack Mounting

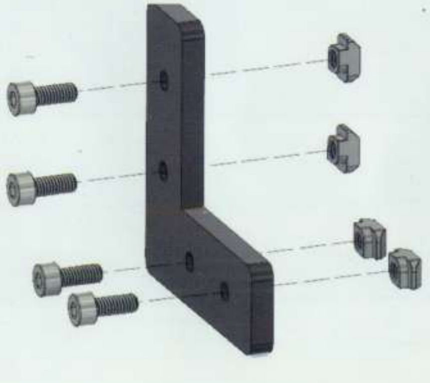


Start the assembly of the frame by sliding the L corner connectors in the 420mm extrusion and 2 on each side

Bag: B-6-3		
Item	**Qty**	**Part Name**
1	1	2040 Extrusion (420mm)
2	2	2040 Extrusion (150mm)
3	4	L Corner Connector

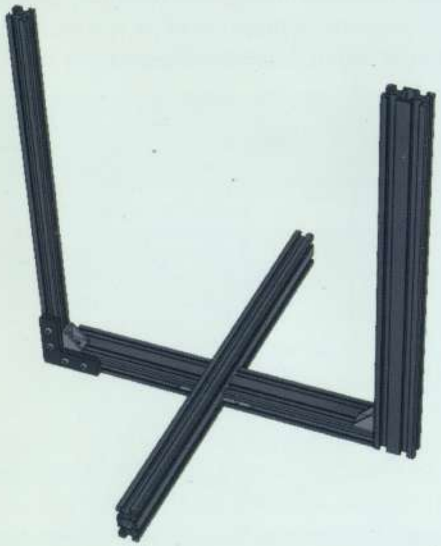


Slide the 150mm long extrusions on L connectors and adjust both of the extrusions distance to 190mm from the front of 420mm extrusion and tighten the scrub screws.



Prepare the 2 L corner pieces as shown in picture.

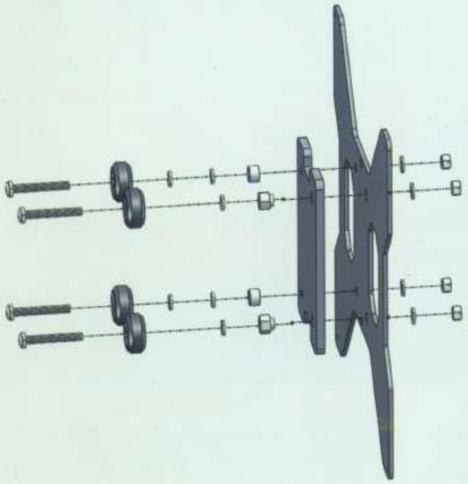
Bag: A-7		
Item	**Qty**	**Part Name**
1	1	Acrylic L Corner Piece
2	4	M4 x 10 bolt
3	4	M4 T Nut



Install the 2040 and 2020 extrusions on side of the 150mm 2040 extrusions as in picture. Use 2028 corner connectors to fasten extrusions in place and mount the acrylic L corner piece as in picture.

Bag: A-7, B-6-2		
Item	**Qty**	**Part Name**
1	1	2028 Corner Connector
2	1	2040 Extrusion (400mm)
3	1	2020 Extrusion (400mm)
4	1	Acrylic L Corner Piece

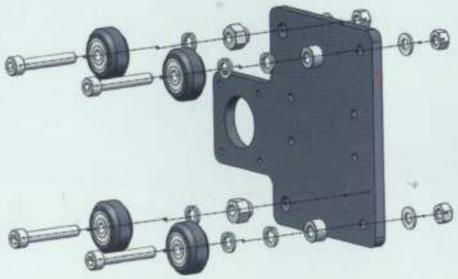
Heated Bed Carriage Assembly



Assemble the heated bed carriage as shown in picture.

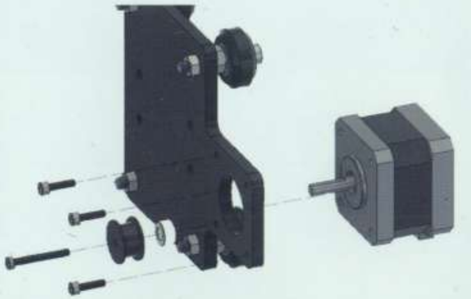
Bag: B-4		
Item	**Qty**	**Part Name**
1	4	M5 x 35 bolt
2	4	V-Slot Wheel
3	6	M5 Spring Washer
4	2	Eccentric Nut
5	2	Nylon Spacer
6	1	Support Plate
7	1	Heated Bed Carriage Plate
8	4	M5 Nut
9	4	M5 Washer

X-Axis Carriage Assembly



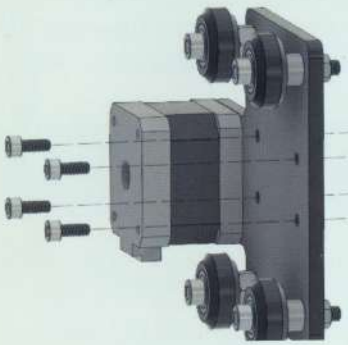
Assemble the wheels to the X motor endplate as shown in picture. DO NOT tighten the nuts too hard as acrylic may get broken.

Bag: B-5		
Item	**Qty**	**Part Name**
1	4	M5 x 30 bolt
2	4	V-Slot Wheel
3	6	M5 Spring Washer
4	2	Eccentric Nut
5	2	Nylon Spacer
6	1	X Motor Endplate
7	4	M5 Nut
8	4	M5 Washer



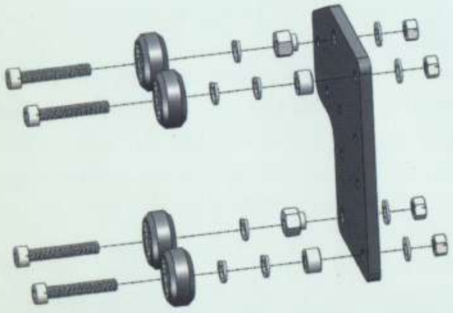
Install the motor and idler as shown in picture. Screw the M3 x 30 bolt all the way in and tighten the M3 nut against the acrylic. Tighten the second nut against idler. (DO NOT overtighten it as the idler has to roll freely.)

Bag: B-5		
Item	**Qty**	**Part Name**
1	1	M3 x 25 bolt
2	3	M3 x 8 bolt
3	1	Idler
4	1	ABS Spacer
5	1	NEMA 17 Stepper Motor



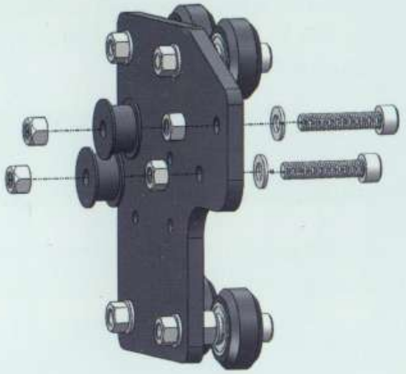
Put the M4 x 10 bolts and M4 T-nuts in place as shown in picture. Leave the M4 T-nuts loose for now.

Bag: B-5		
Item	**Qty**	**Part Name**
1	4	M4 x 10 bolt
2	4	M4 T-nut



Assemble the X idler plate as shown in picture. DO NOT tighten the nuts too hard as acrylic may get broken.

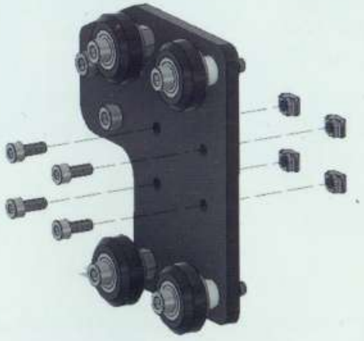
Bag: B-7		
Item	**Qty**	**Part Name**
1	4	M5 x 30 bolt
2	4	V-Slot Wheel
3	6	M5 Spring Washer
4	2	Eccentric Nut
5	2	Nylon Spacer
6	1	Idler Endplate
7	4	M5 Nut
8	4	M5 Washer



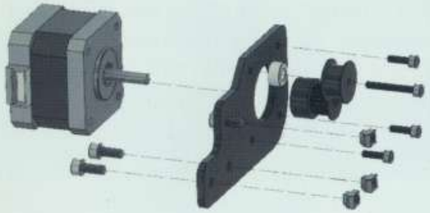
Install the idlers as shown in picture. DO NOT overtighten them as the idlers have to roll freely.

Bag: B-7		
Item	**Qty**	**Part Name**
1	2	M5 Locknut
2	2	Idler
3	2	M5 Nut
4	2	M5 x 25 Bolt
5	2	M5 Washer

Put the M4 x 10 bolts and M4 T-nuts in place as shown in picture. Leave the M4 T-nuts loose for now.

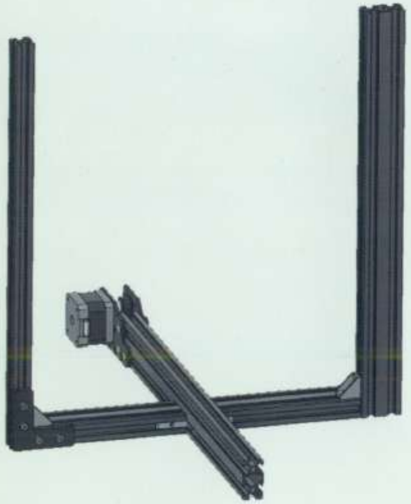


Bag: B-7		
Item	**Qty**	**Part Name**
1	4	M4 T-nut
2	4	M4 x 10 Bolt



Assemble the Y motor bracket as shown in picture. DO NOT overtighten the pulley as it needs to roll freely.

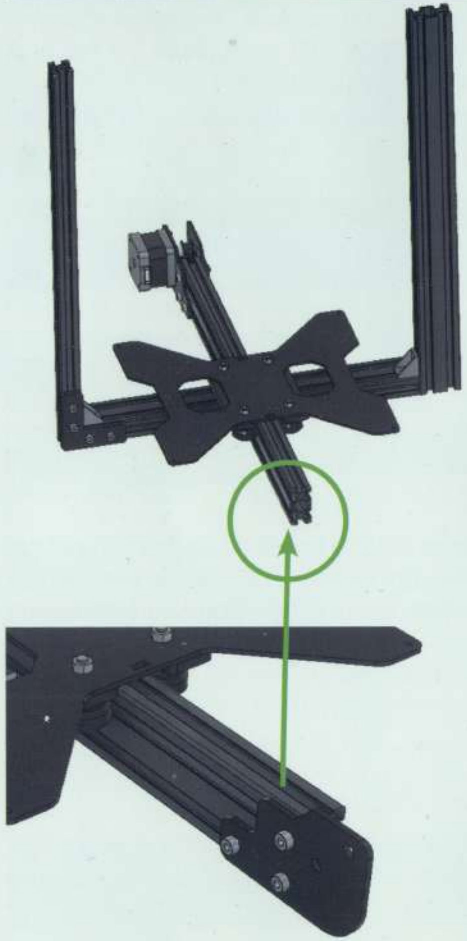
Bag: B-3		
Item	**Qty**	**Part Name**
1	3	M3 x 8 Bolt
2	1	M3 x 25 Bolt
3	1	GT2 Pulley
4	3	M4 T-nuts
5	1	Idler
6	1	Nylon Spacer
7	1	Y Motor Plate
8	3	M4 x 10 Bolt
9	1	NEMA 17 Stepper Motor1

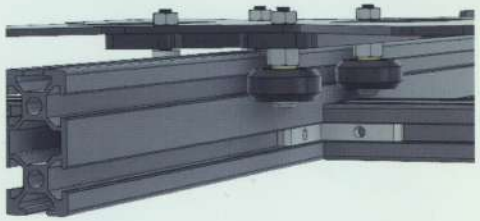


Slide the assembled Y motor bracket on the backside of the printer and tighten the M4 T-nuts. Make sure the T-nuts turns 90 degrees and lock in place. Make sure the idler is not rubbing against the 2040 extrusion, there must be a small gap to let it roll freely.

Y-Axis Installation

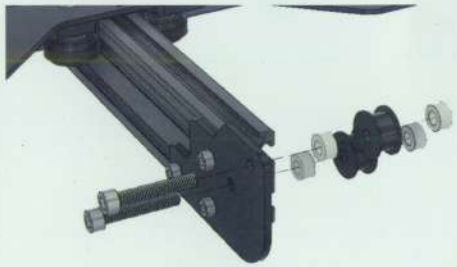
Slide the bed assembly in place and turn the two eccentric nuts so that the wheels press against the extrusion snugly, but the bed will still move smoothly along the extrusion.

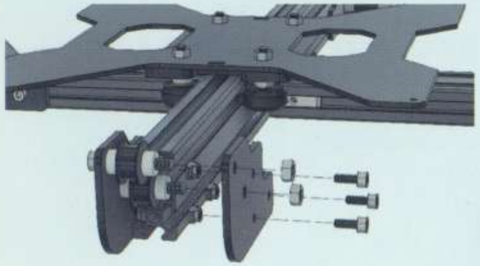




Fix the Y idler plate 1 to the extrusion with M4 bolts and T-nuts as shown in pictures. Put the bolts, nylon spacers and idlers in place as shown in picture.

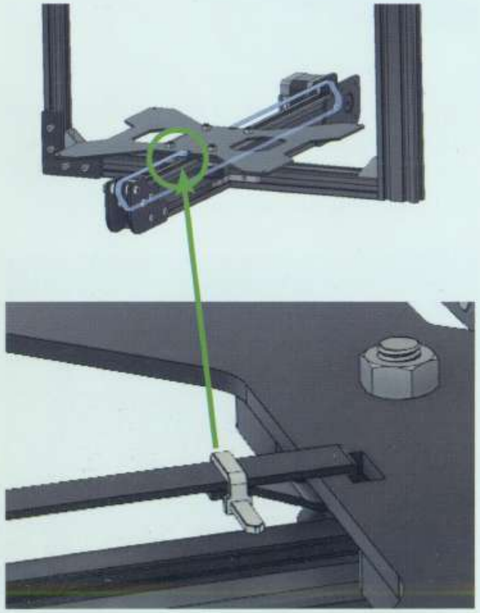
Bag: B-2		
Item	**Qty**	**Part Name**
1	1	Y Idler Plate 1
2	2	M5 x 35 bolt
3	4	Nylon Spacer
4	2	Idler
5	3	M4 T-nut
6	3	M4 x 10 Bolt





Install Y idler plate 2 in place as shown in picture. DO NOT overtighten the M5 nuts as this is lock the idler in place.
Fix the plate in place with M4 bolts and T-nuts.

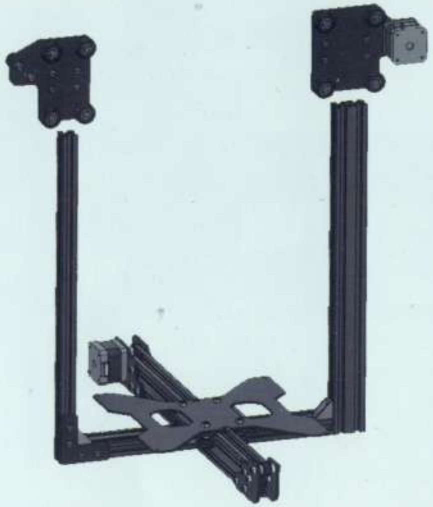
Bag: B-2		
Item	**Qty**	**Part Name**
1	3	M4 T-nut
2	1	Y Idler Plate 2
3	2	M5 Lock Nut
4	3	M4 x 10 Bolt

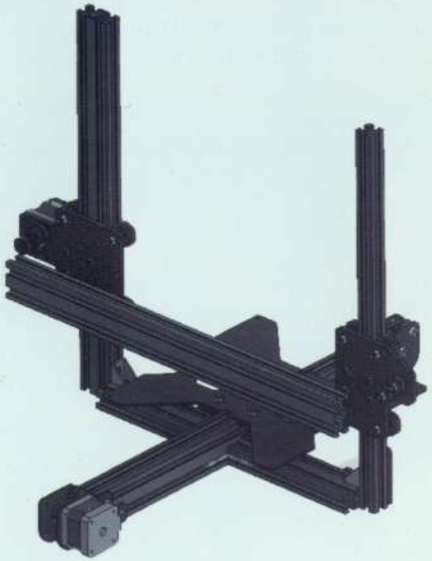


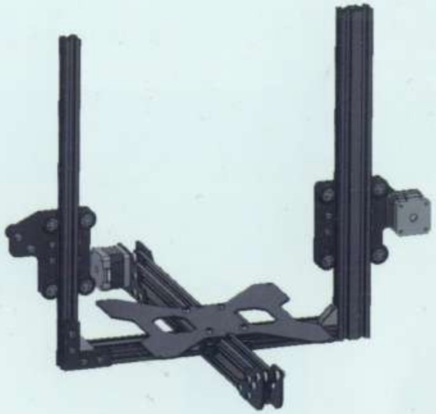
Loop the GT2 belt in Y axis. The belt will run through extrusion as shown in picture (belt is highlighted in light blue color). Make sure the belt go through the square holes on bed carriage and use zip ties to attach belt in place. When doing other side, remember to use little strength to tighten the belt slightly, but DO NOT use too much as the acrylic may get broken.

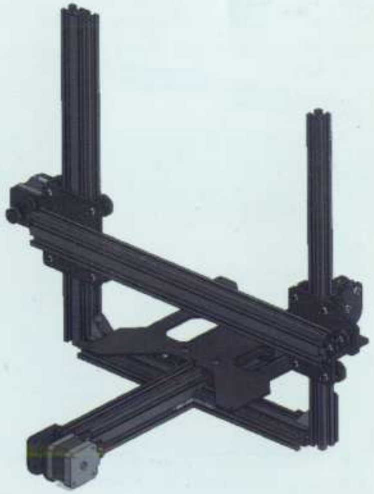
Bag: Belt		
Item	**Qty**	**Part Name**
1	1	GT2 Belt
2	2	Zip Tie

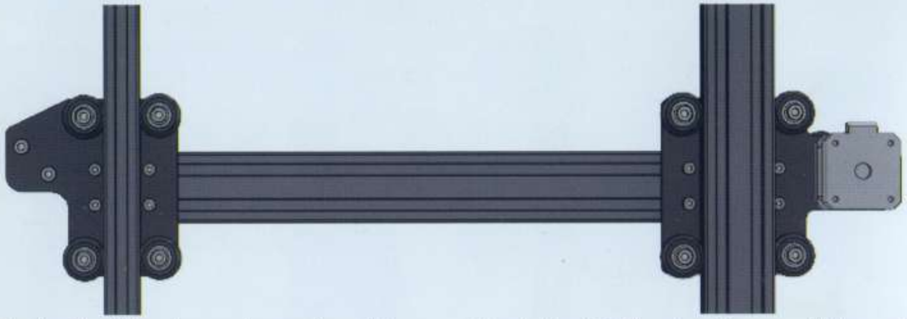
X-Axis Installation







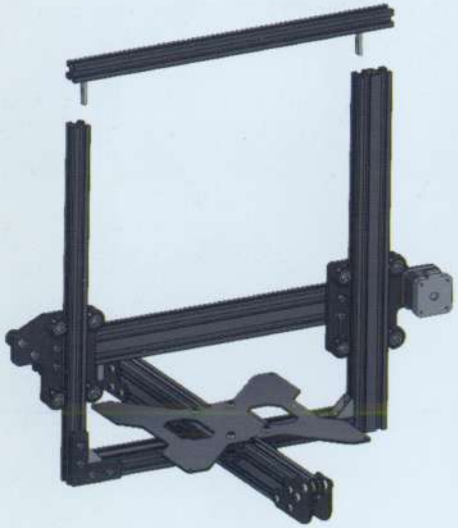




Sllide both slider in as shown in picture. Turn the eccentric nuts on both side so that the sliders feel snug in place, but still roll easily.

Attach the 2040 extrusion on sliders with pre-installed M4 T-nuts. Make sure the T-nuts turns 90 degrees, a drop of screw glue can helps.

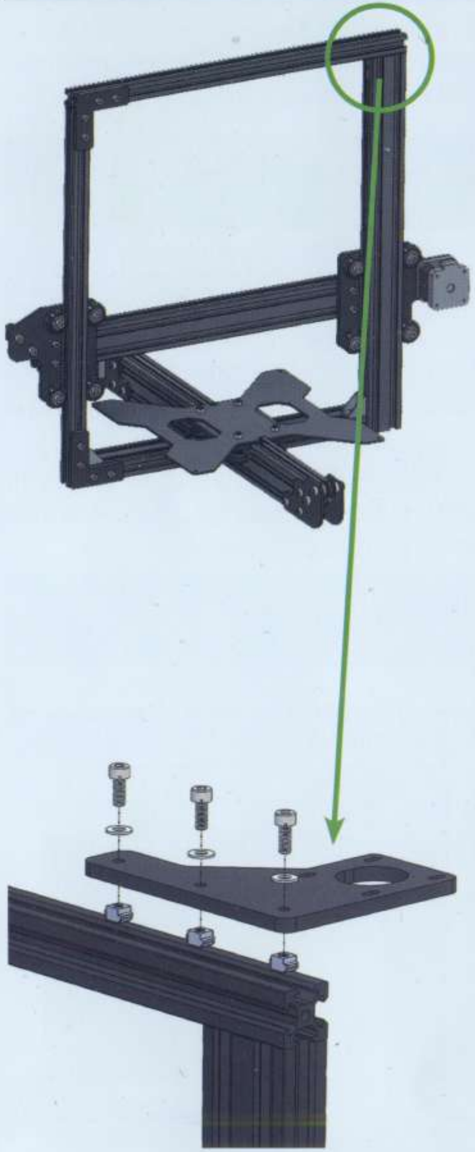
Make sure the extrusion is squared with the frame.



Install the top extrusion in place by using L corner connectors.

Bag: B-6-3		
Item	**Qty**	**Part Name**
1	1	2020 Extrusion
2	2	L Corner Connector

Z-Axis Installation

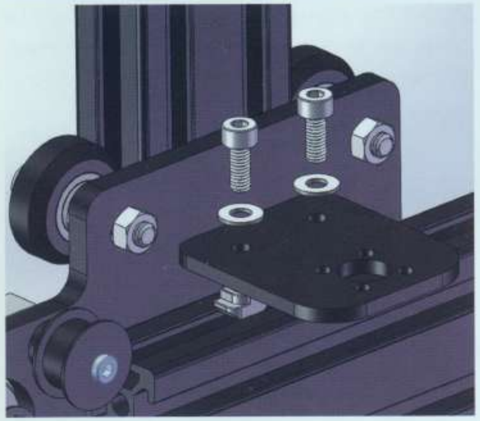


Install the acrylic corner bracket in place as shown in picture with M4 x 10 bolts and M4 T-nuts.

Bag: A-7		
Item	**Qty**	**Part Name**
1	1	Acrylic L Corner Piece

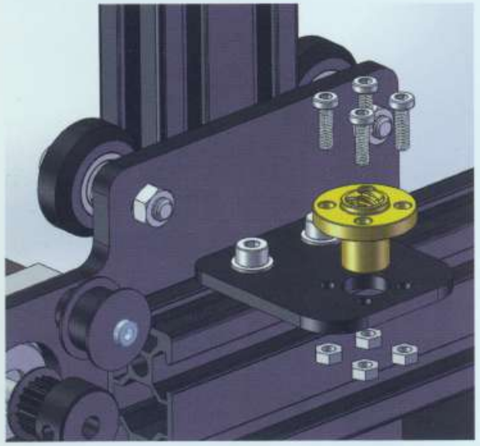
Install the Z motor plate as shown in picture. Make sure the M4 T-nuts turns 90 degrees.

Bag: B-4-2		
Item	**Qty**	**Part Name**
1	3	M4 x 10 bolt
2	1	Z Motor Plate
3	3	M4 T-nut
4	3	M4 Washer



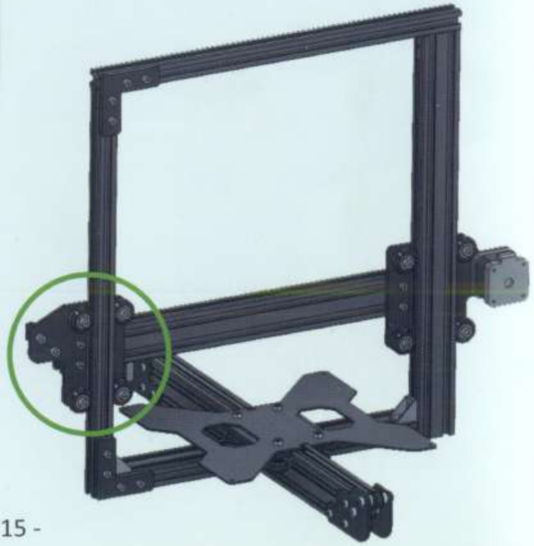
Install the acrylic lead screw nut bracket as shown in picture. DO NOT overtighten the M4 x bolts as acrylic may get broken.

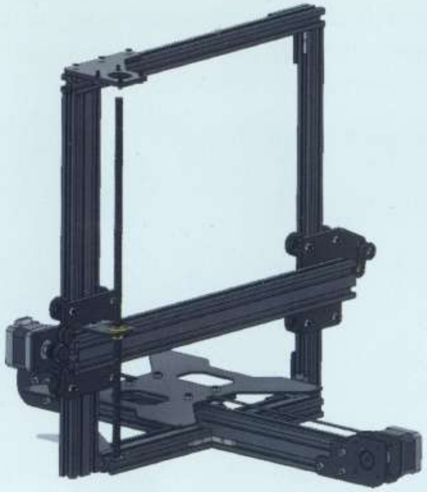
Bag: B-4-1		
Item	**Qty**	**Part Name**
1	2	M4 x 10 bolt
2	1	Lead Screw Nut Bracket
3	2	M4 T-nut
4	2	M4 Washer



Install the lead screw nut as shown in picture. DO NOT overtighten the M3 nuts as acrylic may get broken.

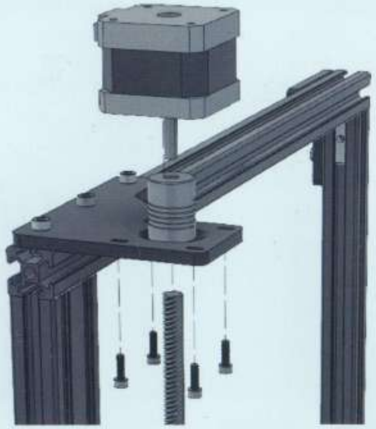
Bag: B-4-1		
Item	**Qty**	**Part Name**
1	4	M3 x 12 bolt
2	1	Lead Screw Nut
3	4	M3 Nut





Install the lead screw by screwing it into the lead screw nut, make sure you leave enough space on top to install stepper motor and flexible coupler.

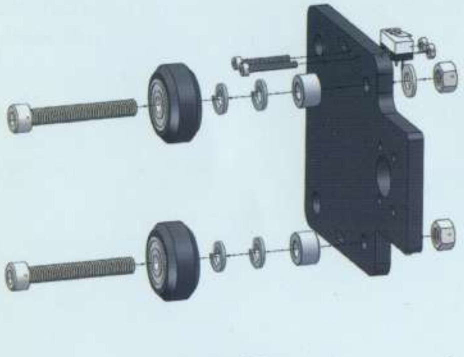
Item	Qty	Part Name
1	1	8mm Acme Lead Screw

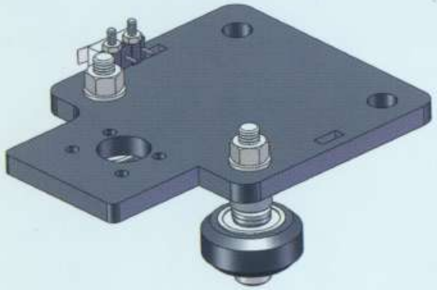


Install the stepper motor, flexible coupler as shown in picture. There are grub screws on both side of the coupler, be sure to loosen it enough to install on the stepper and leadscrew and tighten them afterwards. While tighten the M3 x 10 bolts, you can slide it back and forth to make sure it's parallel with Z extrusion. Also, you may want to slide the whole bracket left or right to make sure the lead screw is not tilting to the side.

Bag: B-4-2		
Item	**Qty**	**Part Name**
1	1	NEMA 17 Stepper Motor
2	1	Flexible Coupler
3	4	M3 x 8 Bolt

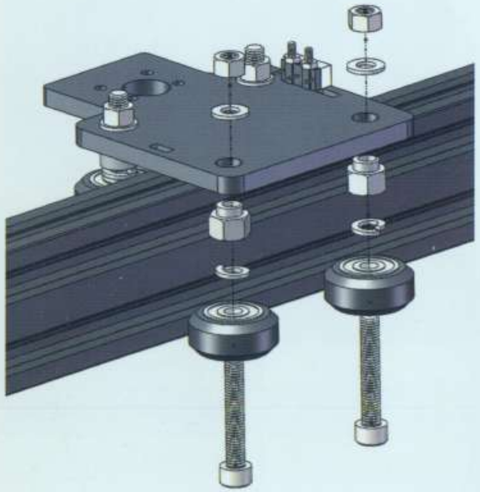
Print Head Carriage Installation





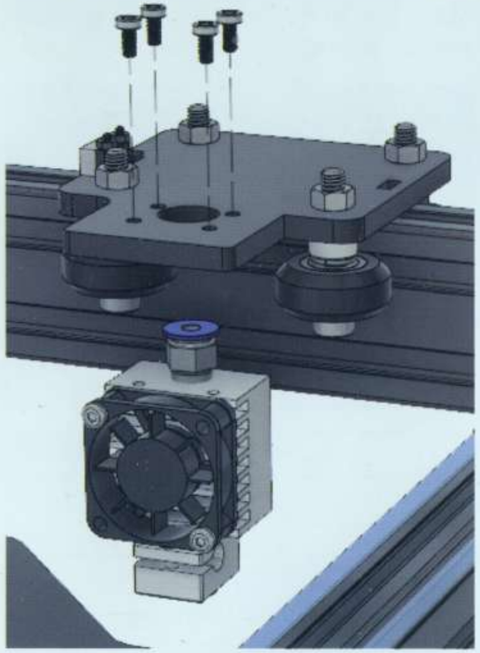
Assemble the hotend carriage as shown in picture. DO NOT overtighten the M5 nuts as arcylic may get broken.

Bag: A-8, A-9		
Item	**Qty**	**Part Name**
1	2	M5 x 30 Bolt
2	2	V-slot Wheel
3	4	M5 Spring Washer
4	2	Nylon Spacer
5	1	Hotend Plate
6	2	M5 Nut
7	2	M2 x 16 Bolt
8	1	Endstop
9	2	M2 Nut
10	2	M5 Washer



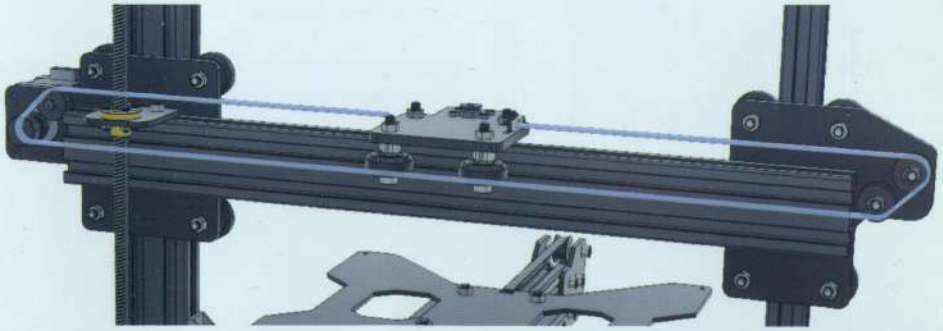
Put the wheels in hotend plate against extrusion slots (Extruder hole facing front of printer) and install the wheels in backside of plate. Adjust the eccentric nuts same way as mentioned earlier. DO NOT overtighten the M5 nuts as acrylic may get broken.

Bag: A-9		
Item	**Qty**	**Part Name**
1	2	M5 Nut
2	2	Eccentric Nut
3	2	M5 Spring Washer
4	2	V-slot Wheel
5	2	M5 x 30 Bolt
6	2	M5 Washer



Install the hotend as shown in picture. DO NOT overtighten the M3 bolts as acrylic may get broken.

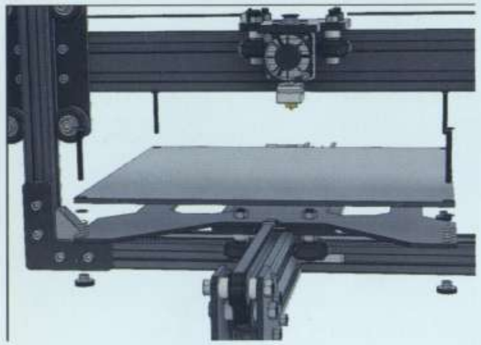
Bag: B-6-1		
Item	**Qty**	**Part Name**
1	4	M3 x 12 Bolt
2	1	Hotend
3	4	M3 x 16 Bolt



Loop the GT2 belt (hightlighted in light blue) as shown in picture. **Be sure the belt go through the middle hole of the extrusion**, and use zip tie to attach both end to the hotend carriage. Make sure the belt is tight.

Bag: Belt		
Item	**Qty**	**Part Name**
1	1	GT2 Belt

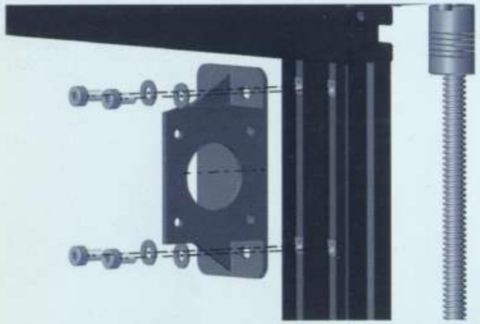
Heated Bed Installation



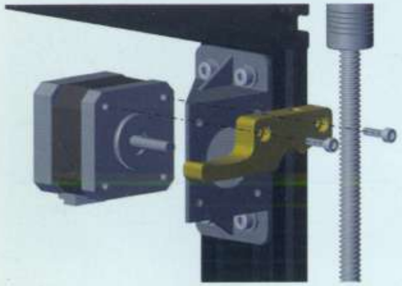
Install the heated bed by using bolt, spring and thumb nut in each corner.

Bag: B-4		
Item	**Qty**	**Part Name**
1	4	M3 Countersink Bolt
2	4	Spring
3	4	M3 Thumb Nut
4	1	Heated Bed
5	4	Insulating Washer

Extruder Installation

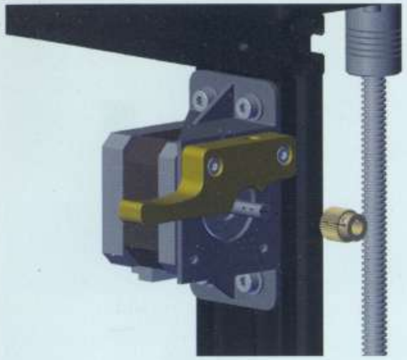


Mount the extruder bracket on 2040 extrusion with M4 x 8 bolt and M4 T-nuts as shown in picture.



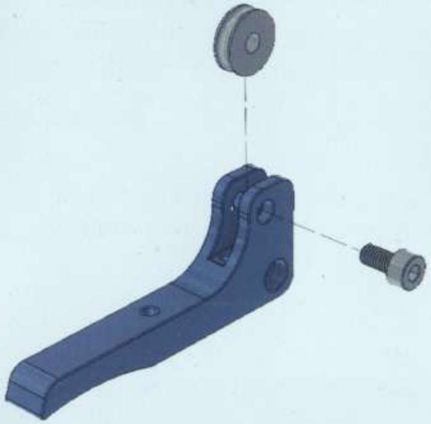
Then mount the extruder top lever and NEMA 17 stepper motor with M3 x 12 bolts as shown in picture.

Bag: B-7-1		
Item	**Qty**	**Part Name**
1	4	M4 T-nut
2	4	M4 x 8 Bolt
3	1	Extruder Bracket
4	1	NEMA 17 Stepper Motor
5	1	Extruder Top Lever
6	2	M3 x 12 Bolt
7	4	M4 Washer



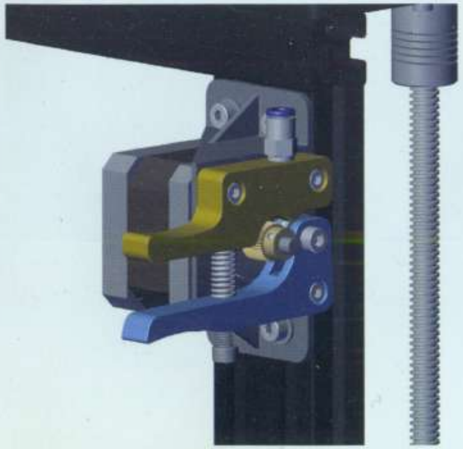
Install the pneumatic connector and extruder gear as shown in picture.

Bag: B-7-1		
Item	**Qty**	**Part Name**
1	1	Pneumatic Connector
2	1	Extruder Gear



Prepare the extruder bottom lever as shown in picture.

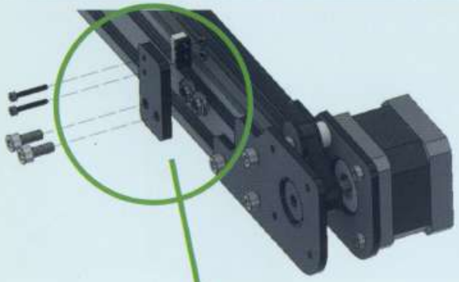
Bag: B-7-1		
Item	**Qty**	**Part Name**
1	1	U Groove Bearing
2	1	M4 x 10 Bolt



Install the bottom lever as shown in picture.

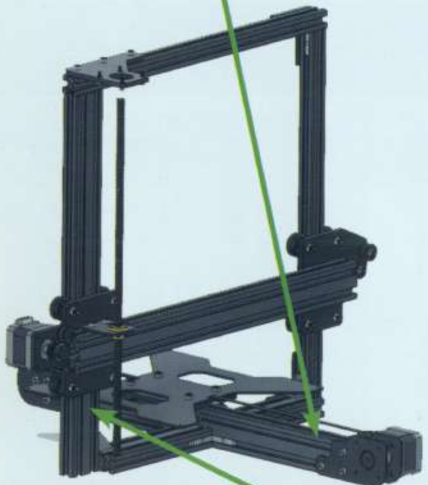
Bag: B-7-1		
Item	**Qty**	**Part Name**
1	1	Assembled Bottom Lever
2	1	M3 x 12 Bolt
3	1	Spring
4	1	M4 Bolt
5	1	M4 x 16 Bolt

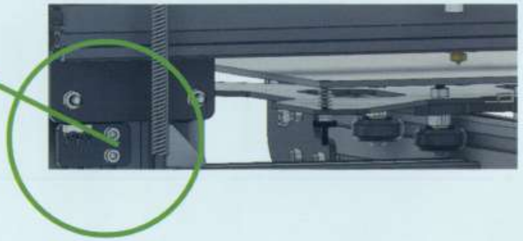
Endstop Installation



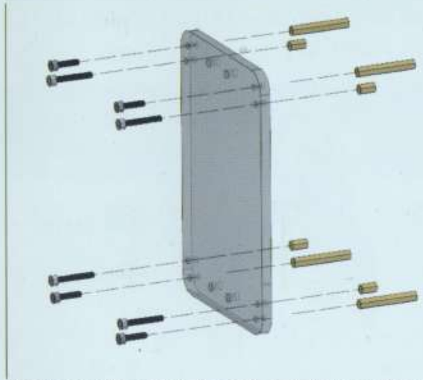
Install the endstops as shown in picture. For a small bed, the Y endstop should be about 10mm away from the Y bracket. Adjust the height of the Z endstop so that the nozzle is touching the bed.

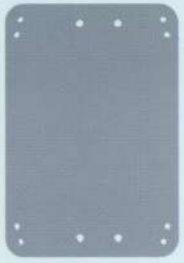
Bag: A-8		
Item	**Qty**	**Part Name**
1	2	M4 x 10 Bolt
2	2	M4 T-nut
3	2	M2 Bolt
4	2	M2 x 16 nut
5	1	Endstop





Controller Board Installation

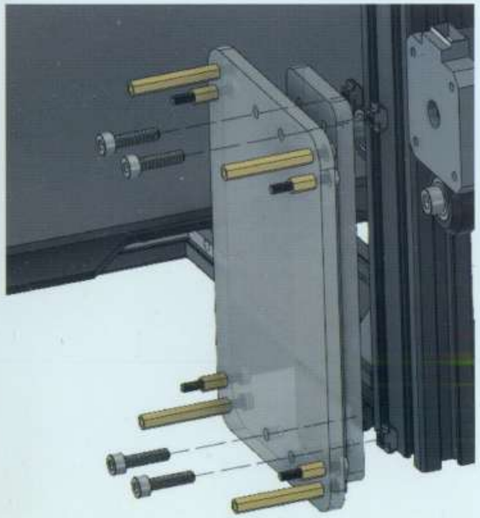




Front View

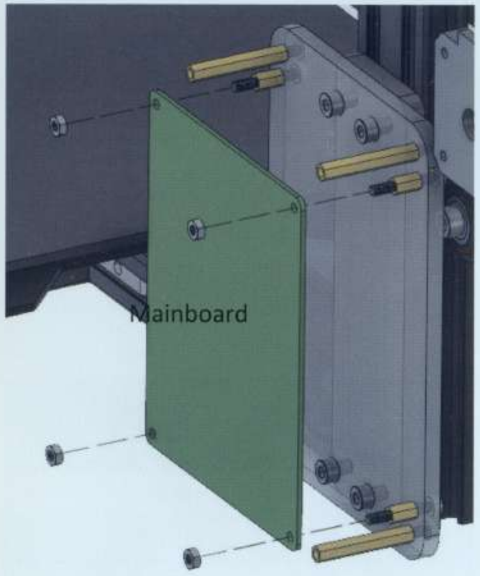
Prepare the mainboard holder as shown in picture. DO NOT overtighten the bolts as acrylic may get broken.

Bag: A-10		
Item	**Qty**	**Part Name**
1	4	M3 x 12 Bolt
2	4	M3 x 20 Bolt
3	4	M3 x 8 Brass Pillar
4	4	M3 x 30 Brass Pillar



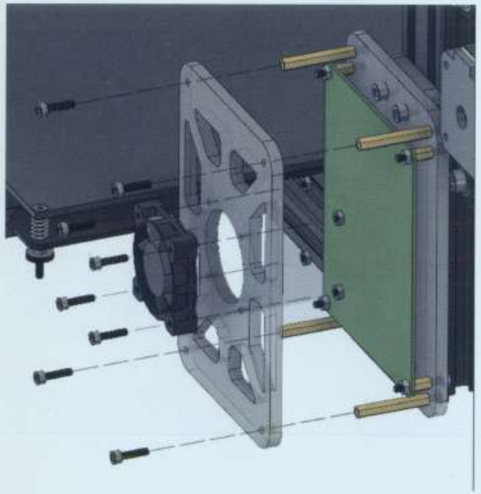
Mount the mainboard holder on the upright 2040 extrusion as shown in picture. Spacer plate should go between the holder and 2040 extrusion. DO NOT overtighten the bolts as acrylic may get broken.

Bag: A-10		
Item	**Qty**	**Part Name**
1	4	M4 T-nut
2	4	M4 x 16 Bolt



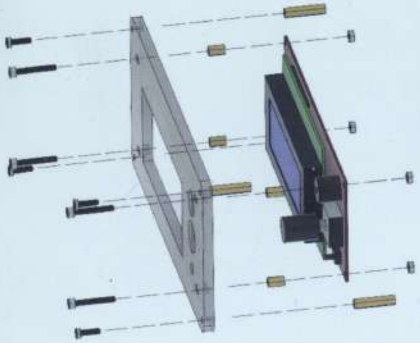
Install the mainboard to the holder as shown in picture.

Bag: A-10		
Item	**Qty**	**Part Name**
1	1	M3 Nut



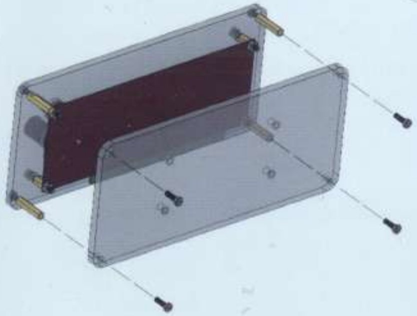
Install the front cover for mainboard as shown in picture. Complete the wiring according to the schematic on Page 30 before this step.

Bag: A-10		
Item	**Qty**	**Part Name**
1	1	Assembled Bottom Lever
2	8	M3 x 12 Bolt



Assemble the LCD and LCD holder front cover as shown in picture.

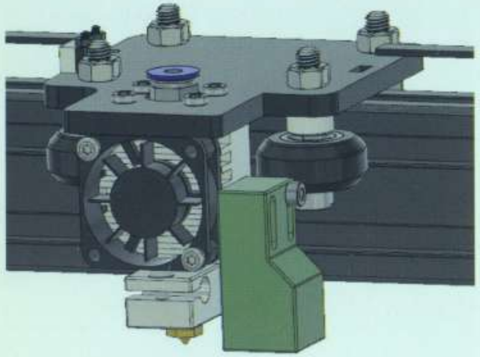
Bag: A-6		
Item	**Qty**	**Part Name**
1	4	M3 Nut
2	4	M3 x 8 Brass Pillar
3	4	M3 x 20 Bolt



[illegible]semble the back cover to the LCD [illegible]lder as shown in picture. You may want to complete the wiring according to the schematic on Page 30 before this step.

Bag: A-6		
Item	**Qty**	**Part Name**
1	8	M3 x 10 Bolt
2	4	M3 x 30 Brass Pillar

Automatic Bed Leveling (Optional)



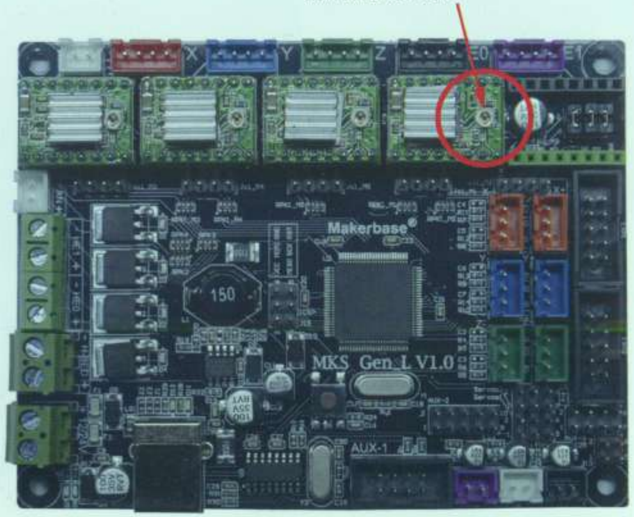
Install the Proximity Sensor as shown in picture. The sensor should be 2mm higher then the nozzle.

Plug the sensor to Z- Endstop socket. And flash the firmware with Auto Level enabled. (You can find it on our Facebook page, or please contact our Customer Service if you need help.)

To use automatic leveling, add G29 command after G28 in slicer starting G-code.

Bag: B-6-2		
Item	**Qty**	**Part Name**
1	2	M3 x 20 Bolt

Stepper Driver Installation



Make sure the trimpot on the stepper drivers are facing the correct direction.

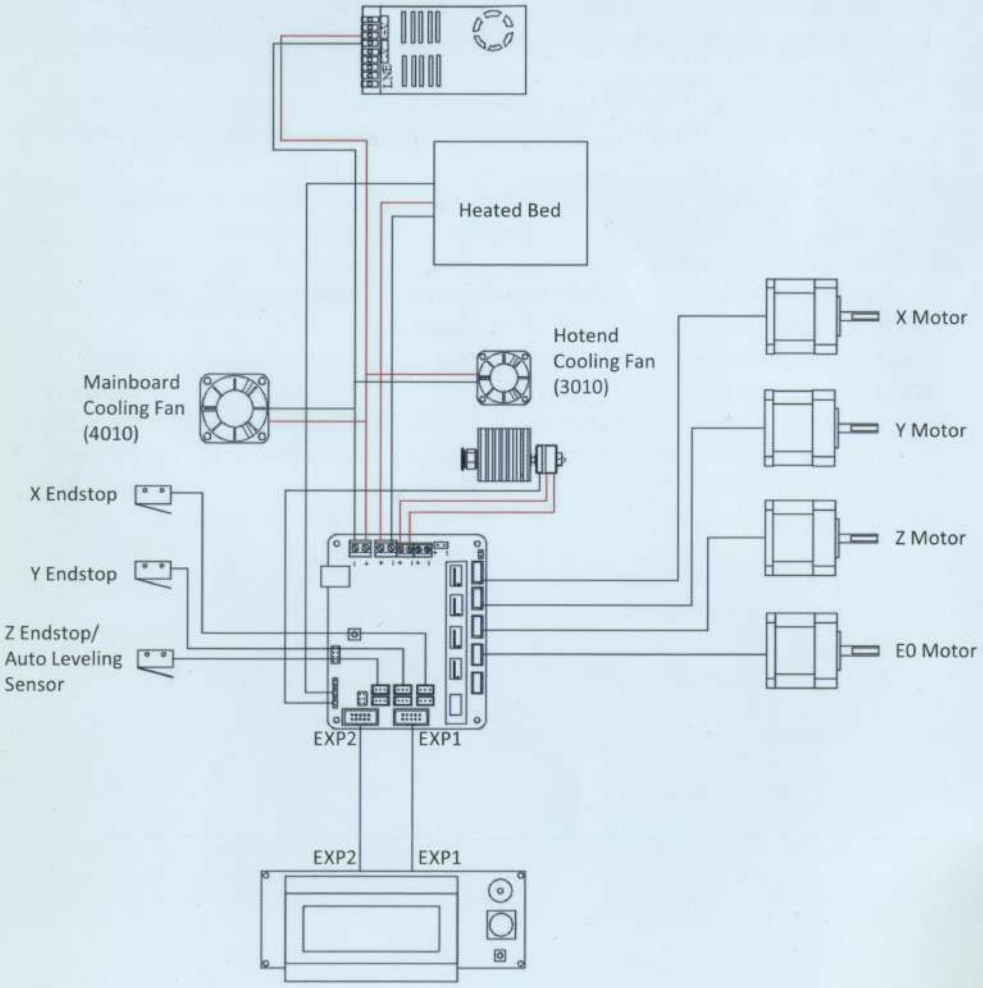
Leveling the Build Plate

To build good parts, the build plate needs to be level, and the nozzle needs to be about 0.1mm from the build plate in all locations. This is about the thickness of a single piece of A4 paper. You want to adjust the height of the build plate so thate you can barely slide the paper between the nozzle and the build plate with only a little resistance.

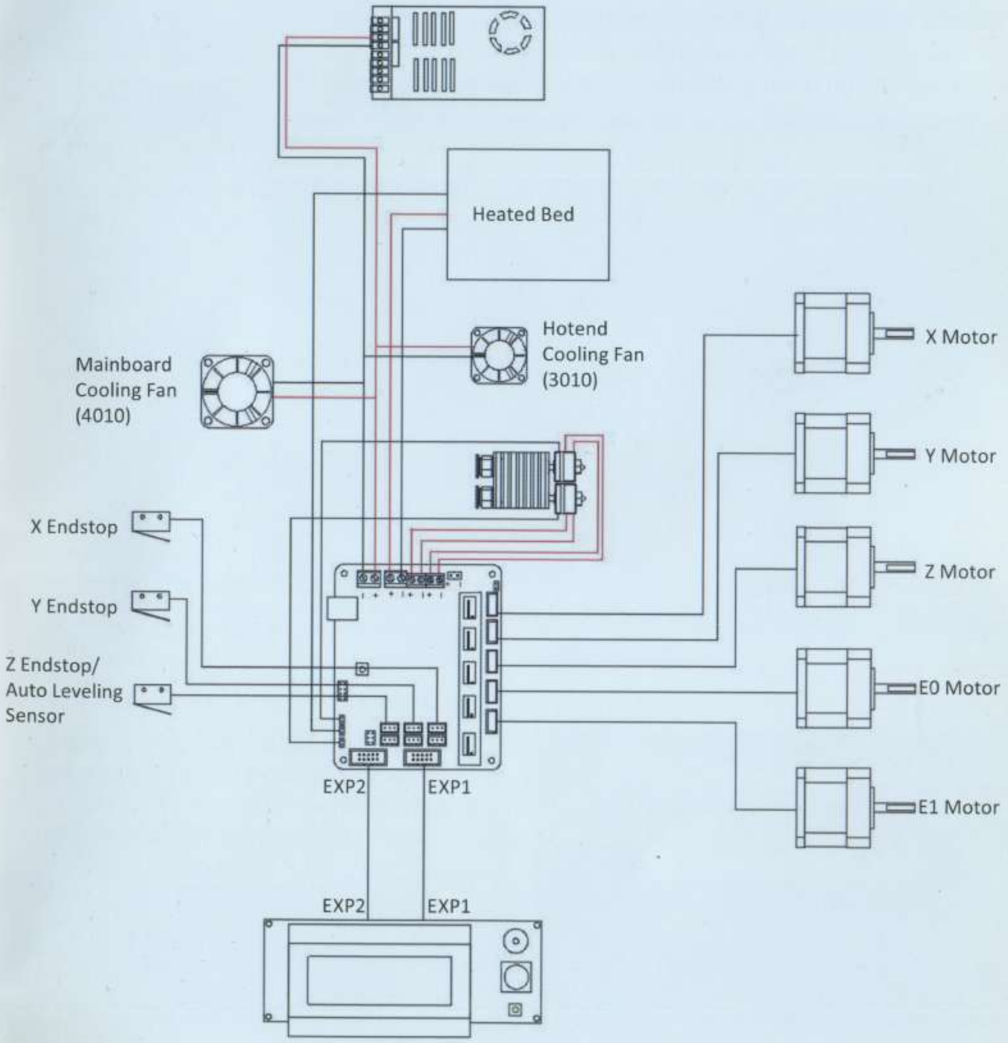
1. Select **Prepare** -> **Preheat PLA**. This will heat up the bed and the nozzle to actual printing conditions, making the leveling more accurate.
2. Select **Prepare** -> **Auto home**. This will move the nozzle to the home position at the front left corner of the build plate.
3. Select **Prepare** -> **Disable steppers**. This will allow you to move the X-carriage and build plate by hand.
4. Tips: The Z-axis stepper motor is also disabled, and you don't want it to move at all. So you should handle the printer gently during the leveling process. Keep it flat and move the X-carriage carefully.
5. Wait for the print bed and nozzle temperature to reach the target temperature. The info screen displays this information below the nozzle and bed icons.
6. Slide a piece of paper between the nozzle and the build plate.
7. Adust each of the four thumbscrews under the bed until the piece of paper slides, with just a bit of drag, in all locations on the build plate.
8. Since adjusting each corner will affect the others, it is strongly suggested to do repeat this process twice.
9. You may need to make fine adjustments to the bed level when you start printing. The first layer of the print will show whether the distance between the nozzle and the build plate is correct. You want it to be pushed into the build surface slightly to maximize surface area contact while still allowing good extrusion flow.
   - You can try to carefully adjust the thumbscrews during the first layer of the print while the plate is moving until the distance between the nozzle and the build plate is producing smooth extruded lines.
   - After you have fine-tuned the bed level during the first layer, you may want to stop the print, clear the build plate, and restart the print.

Wiring Schematic

Connect the mainboard according to the wiring schematic below. The fan connector is meant for print cooling fan (not for the hotend cooling fan, which should be connected directly to 12V). When wired properly your printer should now be ready to be powered up. Please check all cables again before connecting the power supply unit to AC power, also make sure the PSU is set to correct voltage. While powering the printer on for the first time, you should have your hands on the On/Off switch, switch the power off when the printer does not behave correctly.



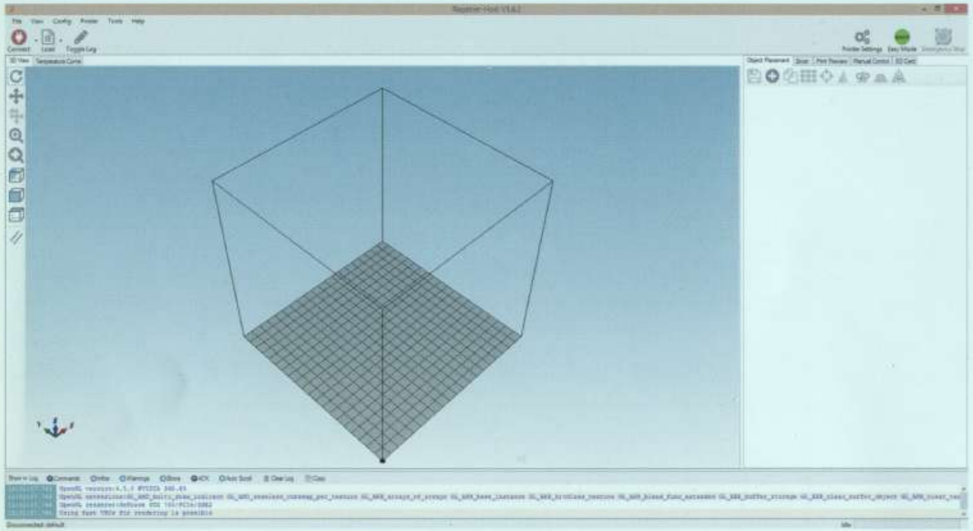
Wiring Schematic for Dual Extruder (Optional)

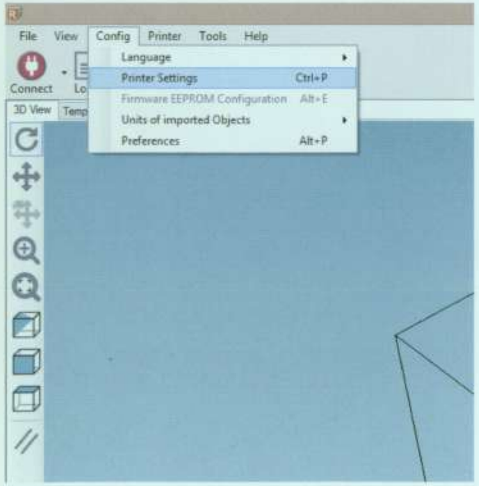


Preparaing Slicing Software

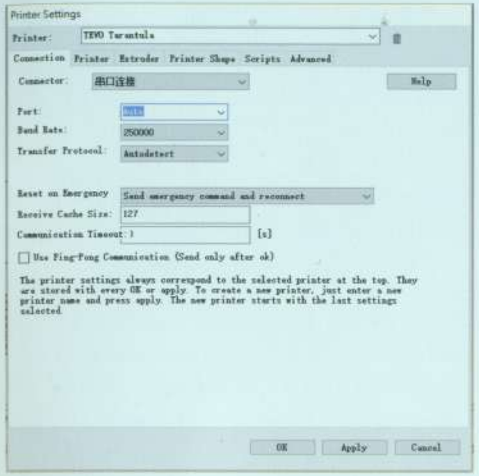
This printer works with most slicing/printing software like Simplify 3D, Cura, Repetier-Host etc. But we will go in details for Repetier-Host software and tell you how to set it up so that you can make your first print. First we recommend you to download the software from their website: https://www.repetier.com/

After installation is done and you start the software, you should get following screen:





Now we have to set up our printer in the settings so that Repetier-Host can connect to it and will know what size of build area our printer use. Open the Printer Settings window (click Config->Printer Settings).



Printer: TEVO Tarantula

Connector: 串口连接

Port: [illegible]

Baud Rate: 250000

Transfer Protocol: Autodetect

Reset on Emergency: Send emergency command and reconnect

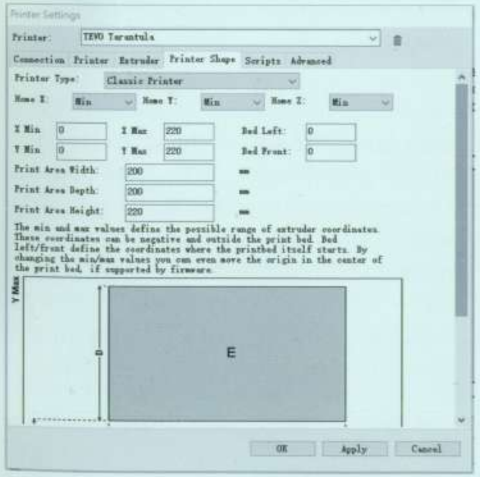
Receive Cache Size: 127

Communication Timeout: [illegible] [s]

☐ Use Ping-Pong Communication (Send only after ok)

The printer settings always correspond to the selected printer at the top. They are stored with every OK or apply. To create a new printer, just enter a new printer name and press apply. The new printer starts with the last settings selected.

First set **Port** to whatever port your mainboard uses (when you have connected your printer to PC it should show up in here). Set **Baud Rate** to 250000 and DO NOT touch any other settings in this tab.



Printer: TEVO Tarantula

Printer Type: Classic Printer

Home X: Min Home Y: Min Home Z: Min

X Min: 0 X Max: 220 Bed Left: 0

Y Min: 0 Y Max: 220 Bed Front: 0

Print Area Width: 200 mm

Print Area Depth: 200 mm

Print Area Height: 220 mm

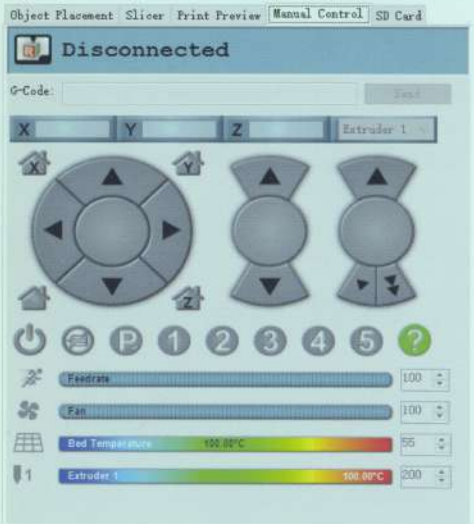
The min and max values define the possible range of extruder coordinates. These coordinates can be negative and outside the print bed. Bed left/front define the coordinates where the printbed itself starts. By changing the min/max values you can even move the origin in the center of the print bed, if supported by firmware.

Click on **Printer Shape** tab, change the following values:

X Max - 220
Y Max - 220 for regular, 280 for large bed

Print Area Width - 200
Print Area Depth - 200 for regular, 260 for large bed
Print Area Height - 220

BLTouch Preparation



Feedrate: 100

Fan: 100

Bed Temperature: 100.00°C, 55

Extruder 1: 100.00°C, 200

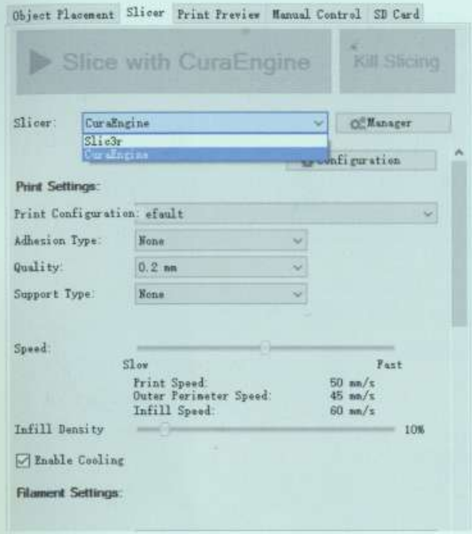
One of the first thing to do before printing is to calibrate BLTouch sensor. We recommend doing this from Repetier-Host. Open up Repetier-Host and connect to the printer. Then, select Manual Control tab.

On this tab, you should see G-Code field as shown in picture. Type in M851 and press send button.

Write down the value you see in the bottom window of Repetier-Host (Log). Then send the next command M851 Z0 following by G28. After that, send G1 Z0.

After this, the LCD screen of printer should show that the position of Z is zero (Z=0). Now you have to use the LCD screen to control the printer. Go to Prepare -> Move Axis -> 0.1mm -> Move Z. Move the Z axis slowly and brings it down to a height that the nozzle is at the right distance from the build plate (A4 paper will feel slight resistance when moving under the nozzle).

Take a note of the current Z value that is shown on LCD screen (it should be negative and lets presume it's -1.1). Then go back to Repetier-Host and send the following command M851 Z-1.1 (remember to use your value from the previous step as it maybe different). Then send M500 to save changes and you're done with the calibration.



Slicer: CuraEngine

Print Configuration: efault

Adhesion Type: None

Quality: 0.2 mm

Support Type: None

Speed: Slow – Fast

Print Speed: 50 mm/s

Outer Perimeter Speed: 45 mm/s

Infill Speed: 60 mm/s

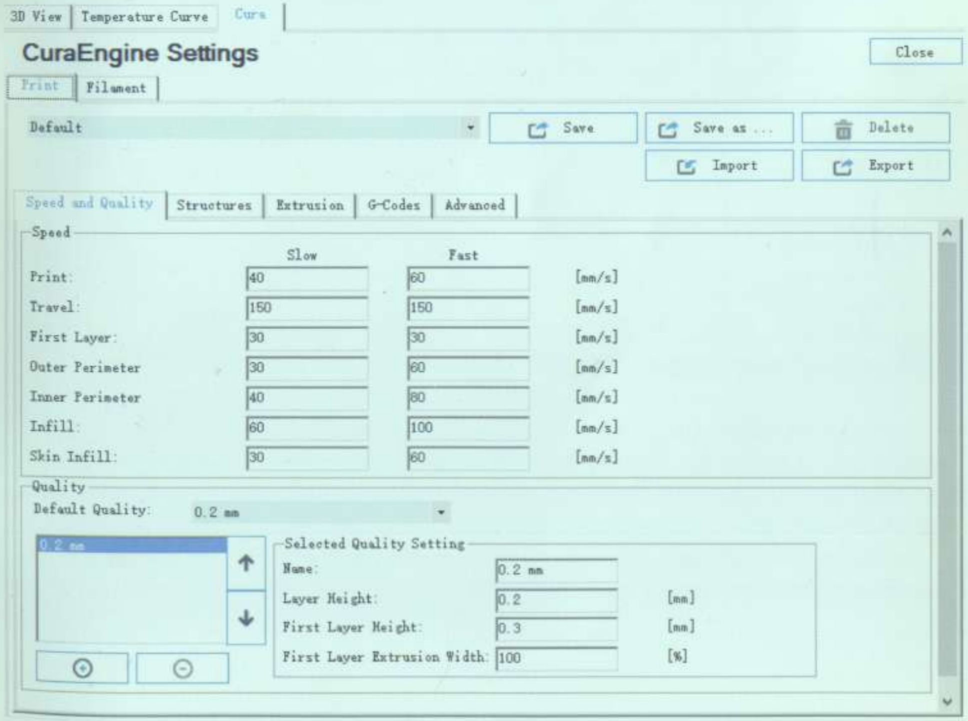
Infill Density 10%

☑ Enable Cooling

For Repetier-Host, it can work with different slicers, but we will show you how to setup CuraEngine for beginners.

On the right side of the main screen, click on Slicer tab and choose CuraEngine in Slicer drop-down box. Then click on Configuration.

You can adjust layer height, printing speed, etc. on Speed and Quality tab. But the most important would be Filament tab, on this tab, you will need to set the Temperature for Nozzle and Bed according to your filament.



Default

	Slow	Fast	
Print:	40	60	[mm/s]
Travel:	150	150	[mm/s]
First Layer:	30	30	[mm/s]
Outer Perimeter	30	60	[mm/s]
Inner Perimeter	40	80	[mm/s]
Infill:	60	100	[mm/s]
Skin Infill:	30	60	[mm/s]

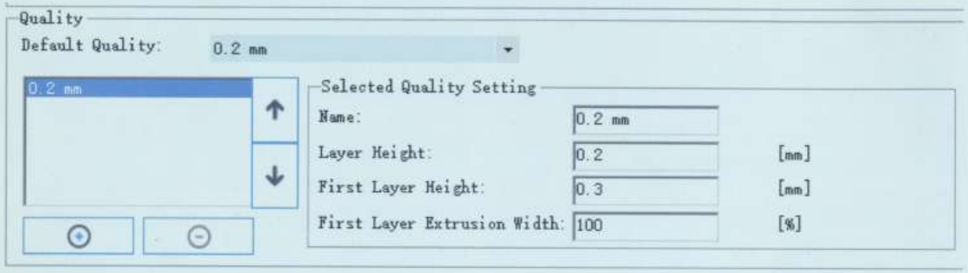
Default Quality: 0.2 mm

Name: 0.2 mm

Layer Height: 0.2 [mm]

First Layer Height: 0.3 [mm]

First Layer Extrusion Width: 100 [%]



Default Quality: 0.2 mm

0.2 mm

Name: 0.2 mm

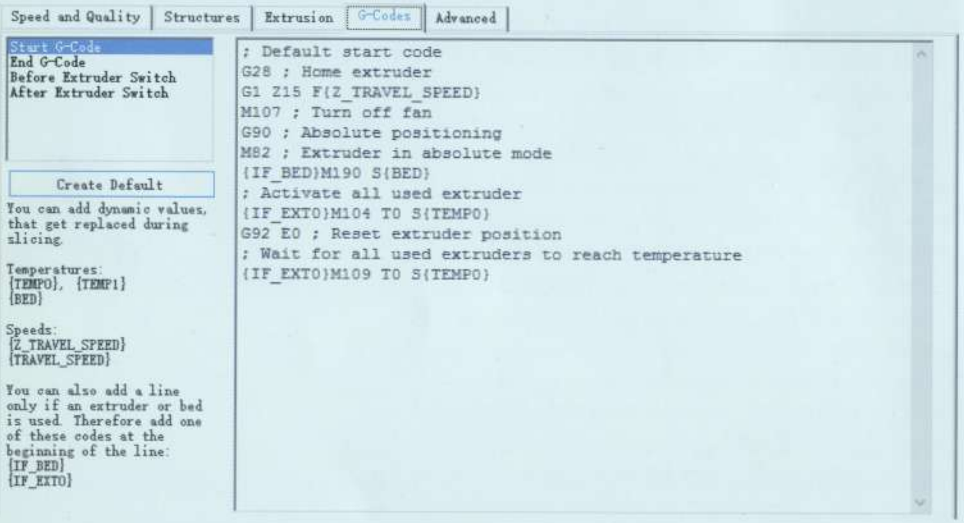
Layer Height: 0.2 [mm]

First Layer Height: 0.3 [mm]

First Layer Extrusion Width: 100 [%]

In most cases, the default setting is good enough to get it started, buy you may want to play around with the layer height to get a finer details, also, you may want to adjust the printing speed accordingly.

For users with automatic bed leveling, you need to add G28 command in the tab below.



You can add dynamic values, that get replaced during slicing.

Temperatures:
{TEMPO}, {TEMP1}
{BED}

Speeds:
{Z_TRAVEL_SPEED}
{TRAVEL_SPEED}

You can also add a line only if an extruder or bed is used. Therefore add one of these codes at the beginning of the line:
{IF_BED}
{IF_EXTO}

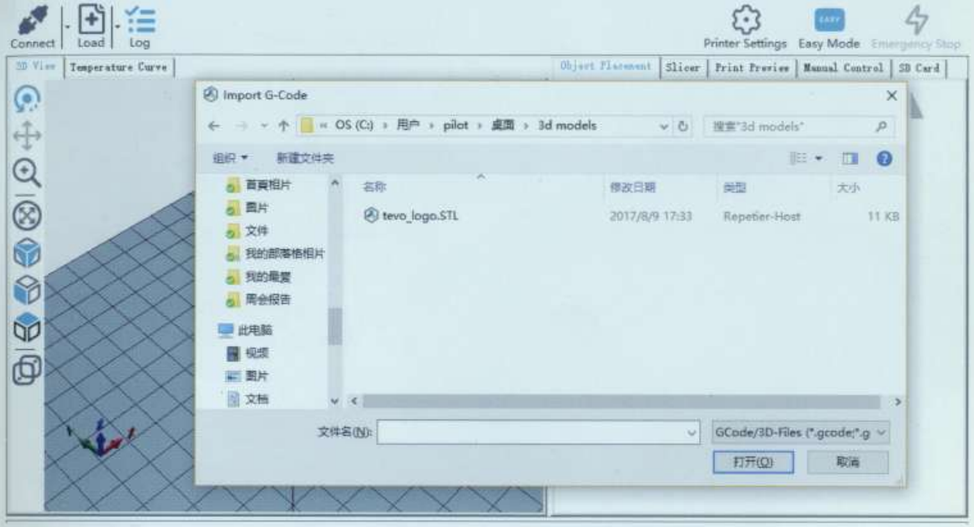
```
; Default start code
G28 ; Home extruder
G1 Z15 F{Z_TRAVEL_SPEED}
M107 ; Turn off fan
G90 ; Absolute positioning
M82 ; Extruder in absolute mode
{IF_BED}M190 S{BED}
; Activate all used extruder
{IF_EXT0}M104 T0 S{TEMP0}
G92 E0 ; Reset extruder position
; Wait for all used extruders to reach temperature
{IF_EXT0}M109 T0 S{TEMP0}
```

When all the adjustment have been made, you just need to go back to the first tab (3D View), drag and drop a STL / AMF / 3MF (or other supported 3D model files) to Repetier-Host, then click on Slice with CuraEngine (or Slice with Slic3r if you have chosen Slic3r as your slicing engine).

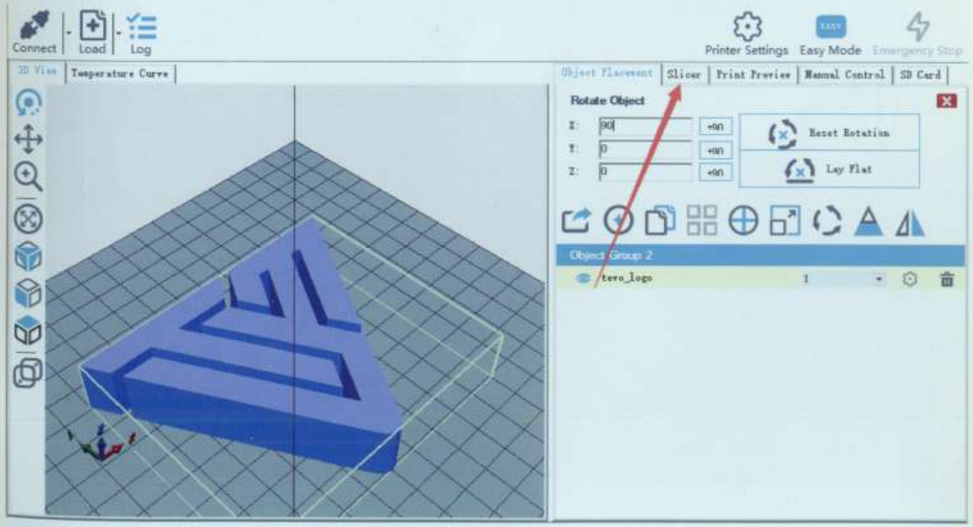
When slicing is finish, you can choose your preferred way to start printing, either connected to the computer, or save the Gcode file to SD Card and printing offline.

How to Slice 3D Object for SD Print

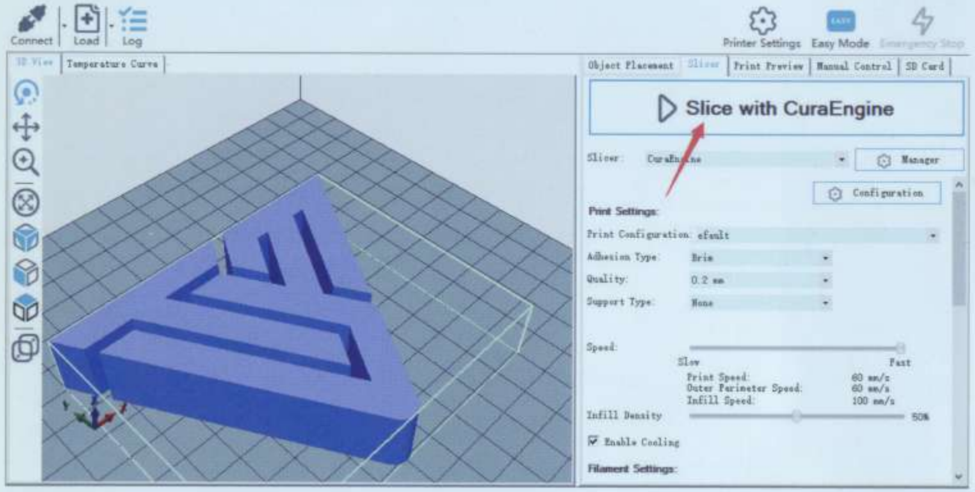
Click on Load, browse to location of the file, then choose Open.



After the file is open up in 3D view, click on Slicer tab to go into slicing page.



Select the correct Print Setting, Printer Settings, and Extruder type, then click on Slice with Slic3r.



Slicer: CuraEngine

Print Configuration: efault

Adhesion Type: Brim

Quality: 0.2 mm

Support Type: None

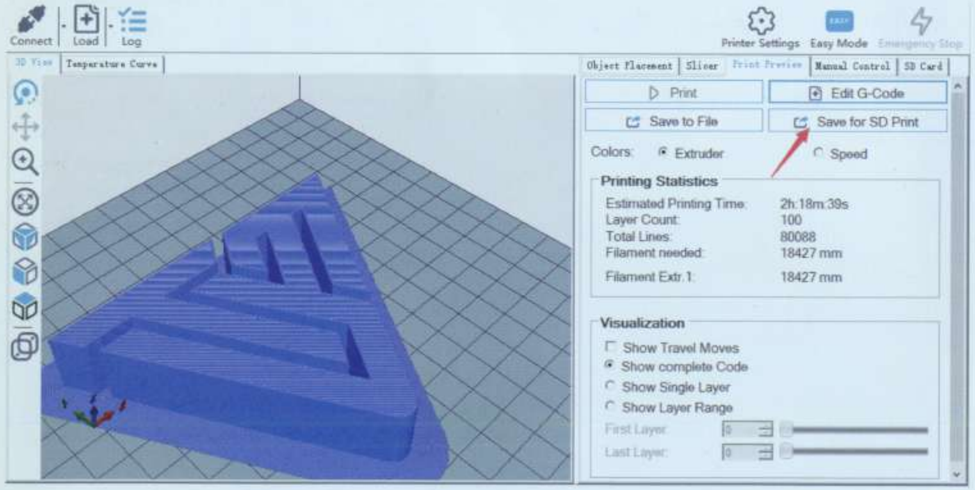
Speed: Slow – Fast

Print Speed: 60 mm/s
Outer Perimeter Speed: 60 mm/s
Infill Speed: 100 mm/s

Infill Density 50%

☑ Enable Cooling

After slicing, click on Save for SD Print to save the G-code file to the SD card with file name of your choice. Then you can insert the card to your printer and choose Print from SD to start printing.



Colors: ● Extruder ○ Speed

Estimated Printing Time: 2h:18m:39s
Layer Count: 100
Total Lines: 80088
Filament needed: 18427 mm
Filament Extr.1: 18427 mm

☐ Show Travel Moves
● Show complete Code
○ Show Single Layer
○ Show Layer Range
First Layer: 0
Last Layer: 0

How to Flash Firmware

To install firmware on your printer, you'll need to download the following:

1. Arduino IDE (http://www.arduino.cc)
2. Firmware Source Code (You can get it from many ways, e.g. our Facebook Page Files section, our Customer Service, or from Marlin and Repetier directly.)

In this chapter, we're going to use Marlin for demonstration.

Configuration

Firmware downloaded from our Facebook page or from our customer service are pre-configured, you can use it without any modification.

To configure, you'll need to edit two files: **configuration.h** and **configuration_adv.h**. You can visit their website for explanations of the configuration file format and a synopsis of most of the options in these files.

Verify / Compile

To start the process, do the following steps:

1. Double-click **Marlin.ino** file to open it in Arduino IDE.
2. Select **Arduino/Genuino Mega or Mega 2560** from **Tools** -> **Boards** menu.
3. Select the serial (USB) port that your board is connected to in **Tools** -> **Serial Port** menu.
4. Click the **Verify/Compile** button at the top of the window to make sure there are no configuration errors. (Or you can click on **Upload** button next to Verify/Compile if you're using Marlin from our Facebook page or our customer service).
5. Once all errors are fixed, proceed with the upload by clicking **Upload** button. A blue or green LED on the board will flash rapidly during this process.

Flash Your Board

To flash your board, do the following steps:

1. Ensure Marlin.ino is open in the Arduino IDE.
2. Select **Arduino/Genuino Mega or Mega 2560** from **Tools** -> **Boards** menu.
3. Select the serial (USB) port that your board is connected to in **Tools** -> **Serial Port** menu.
4. Click on Upload button to begin flashing your controller board. A blue or green LED on the board will flash rapidly during this process.

That's it! Now you've flashed firmware to your board, enjoy printing!

TEVO After-Sales

Dear Customer,

Thank you for purchasing TEVO 3D printer. We are dedicated to producing low price, high quality 3D printers and hope you have as much fun using it as we did creating it!

If you have any issue/questions regarding the contents in the kit, please fill out a Service Ticket on our Support page.

http://support.tevoprinter.com

Creating a Service Ticket will serve as your official request for TEVO support. Our Customer Support Team will contact you within **48 hours**.

SERVICE INFORMATION:

1. **REPLACEMENT PARTS**
   - 1.1. TEVO products are covered under a Replacement Part Program for a period of **12 months** from the date of purchase.
   - 1.2. Missing/Damaged/Defective Parts
     - 1.2.1. **Within 7 days** of the delivery date, TEVO will replace any parts free of charge including shipping fees.
     - 1.2.2. **After 7 days** of the delivery date, TEVO will replace any parts free of charge BUT the customer will be responsible for shipping fees.
   - 1.3. Customer Damaged Parts
     - 1.3.1. The customer shall pay for the cost of the parts AND the shipping fees.

2. **CARRIER LOSS, MIISSING, DAMAGED, AND DEFECTIVE PARTS**
   - 2.1. Claims for lost or damaged shipments must be reported to the carrier within the carrier's claim window, the customer needs to inform TEVO within **7 days** of the delivery date.
     - 2.1.1. For any parts lost or damaged during shipping, the customer shall take photos or video and submit them when filling out a Service Ticket. If a claim number was issued by the carrier, please include the claim number when creating your Service Ticket (**Report a Problem / Carrier Lost Parts.**)
     - 2.1.2. Once the Carrier dispute is resolved, please provide TEVO with all communications with the carrier. It is the customer's responsibility to keep TEVO up to date with ALL communications with the carrier.
     - 2.1.3. TEVO will work with the customer on replacing the parts in the claim.
   - 2.2. For Missing Parts, refer to section 1.2, the customer shall fill out a Service Ticket (**Report a Problem / Missing Parts.**)
   - 2.3. For Damaged Hardware Parts, refer to section 1.2, the customer shall take photos or video and submit them when filling out a Service Ticket (**Report a Problem / Damaged Hardware Parts.**)
   - 2.4. For Defective Electronic Parts, refer to section 1.2, the customer shall take photos or video and submit them when filling out a Service Ticket (**Report a Problem / Defective Electronic Parts.**)
     - 2.4.1. If the part is the LCD Panel, Power Supply or Mainboard, the customer shall ship the part back to TEVO and TEVO will send a new part.
   - 2.5. For parts damaged by the customer, refer to section 1.3, submit a Service Ticket (**Report a Problem / Customer Damaged Parts.**)

3. **GENERAL SUPPORT**

For information and support on building and operating your TEVO Tarantula 3D printer, please visit the TEVO Tarantula Owners Group.

https://www.facebook.com/groups/TEVO.3dprinter.owners/